

Work Order ID 62007

Wednesday, September 15, 2010 9:56:28 AM

Page 1

Item ID: D3536-13

Accept

Setup Start

Revision ID:

Stop

Item Name: Gasket

Start Date: 9/14/2010 Start Qty: 10.00

Cust Item ID:

Required Date: 9/21/2010 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan: HDate: 10-9-15

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3536

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3536 ☐ Dwg Rev: A ☐ Prog Rev: A ☐ 2-
Deburr if necessary13 10-9-21

(12)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

13 10-9-21

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

5/10/12

(412)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Page 2

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Cust Item ID:

Required Date: 9/21/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

10/9/22 SF (120)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/23 JF
MF 10-9-22

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NOTE: Date & initial all entries

Picklist Print

Wednesday, September 15, 2010 9:56:33 AM

Page 1

Work Order ID: 62007

Parent Item: D3536-13

Parent Item Name: Gasket



Start Date: 9/14/2010

Required Date: 9/21/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063 		Purchased	No			100	sf	477.6133	0.8269	8.704211	10.		
NEOPRENE SHEET 0.063											1810-9-21		

Location

Loc Qty

Loc Code

MAT

372.3602

114691

105.9602

115500

266.4

MAT052

105.2531

114176

105.2531

115500

(12)

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	62007
Description: Gasket		Part Number:	D3536-13
Inspection Dwg: D3536 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
32.90	+/-0.030	32.90	x		TB 61	
29.40	+/-0.030	29.40	x		T	
27.40	+/-0.030	27.40	x		T	
23.90	+/-0.030	23.90	x		T	
18.98	+/-0.030	18.98	x		T	
14.07	+/-0.030	14.07	x		T	
9.15	+/-0.030	9.15	x		T	
5.65	+/-0.030	5.652	x		V TB 62	
3.90	+/-0.030	3.903	x		V	
8.00	+/-0.030	8.00	x		T	
14.00	+/-0.030	14.00	x		T	
20.00	+/-0.030	20.00	x		T	
1.89	+/-0.030	1.895	x		V	
0.30	+/-0.030	.300	x		V	
0.30	+/-0.030	.300	x		V	
Ø0.19	+0.005/-0.001	.190	x		V	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 10-9-21	Date: 10/09/22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.06.13	New Issue	KJ/JLM	B

W/O:		WORK ORDER CHANGES					
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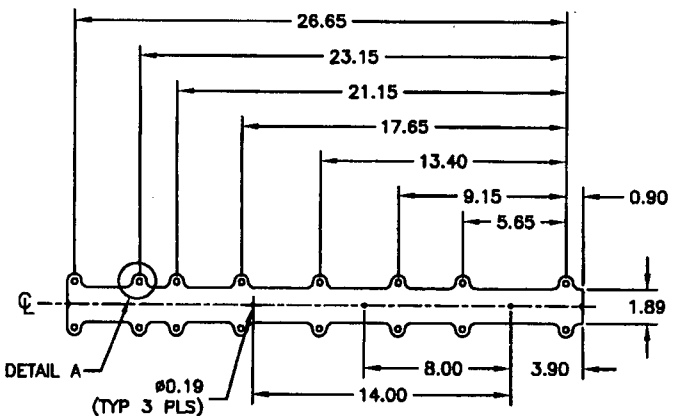
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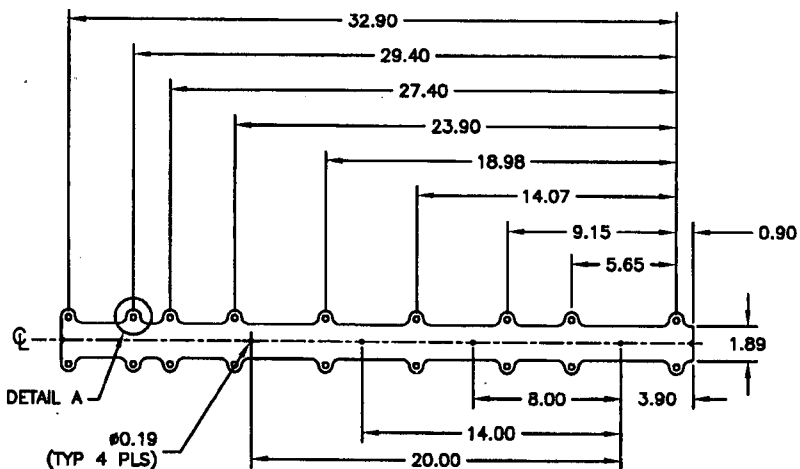
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CB	CB	PORT HADLOCK, WA	
CHECKED PH	APPROVED H	DRAWING NO. D3536	REV. A
DATE 06.10.25		TITLE GASKET	SHEET 1 OF 6
A	06.10.25	NEW ISSUE	SCALE 1:10

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09.02.12-1

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ENGINEERING
UNCONTROLLED COPY
SUPERSEDED BY
VOLUME 1
NO. 42607
P/109-15



D3536-11 GASKET



D3536-13 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

W/O:		WORK ORDER CHANGES					
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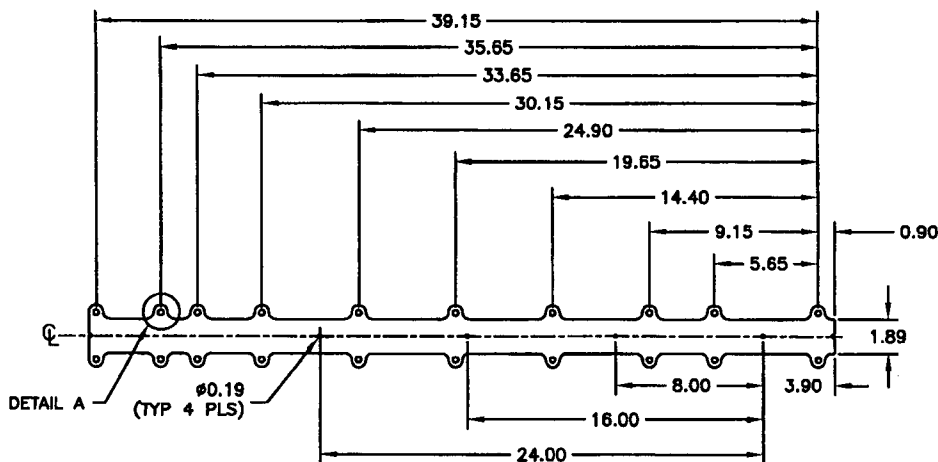
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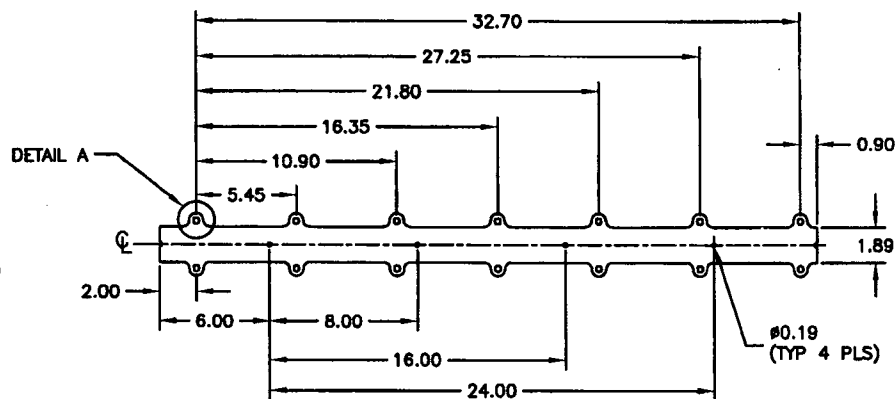
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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 2 OF 6
		SCALE	1:10	

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W/042001



D3536-15 GASKET



D3536-21 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE080-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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Dart Aerospace Ltd

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

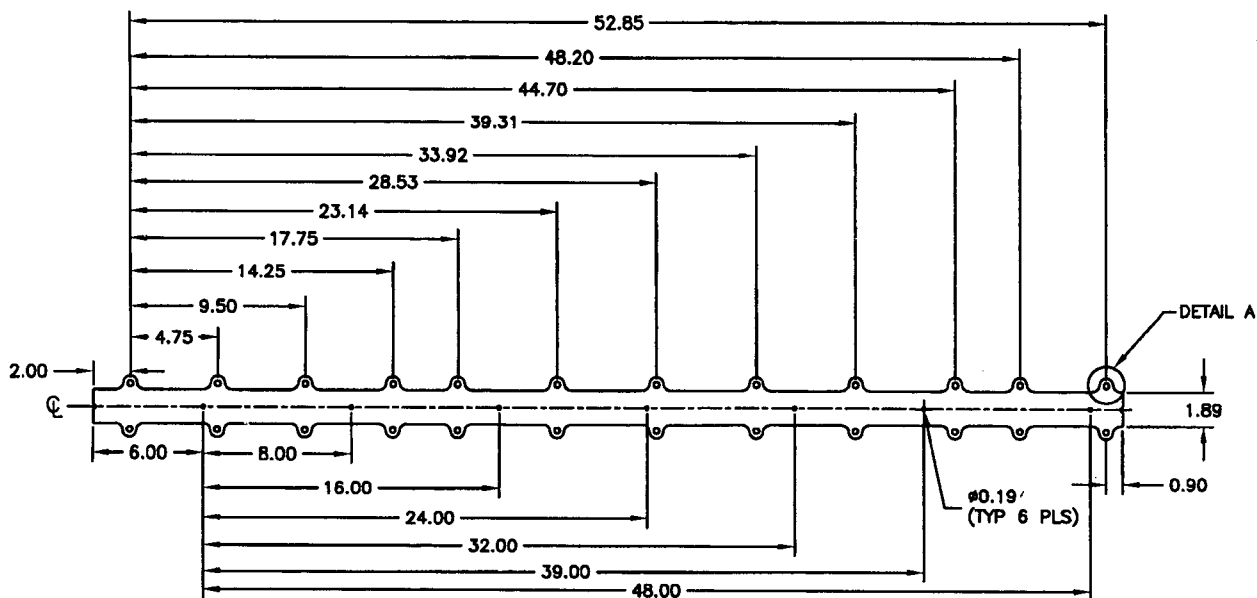
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NOTE: Date & initial all entries

DART

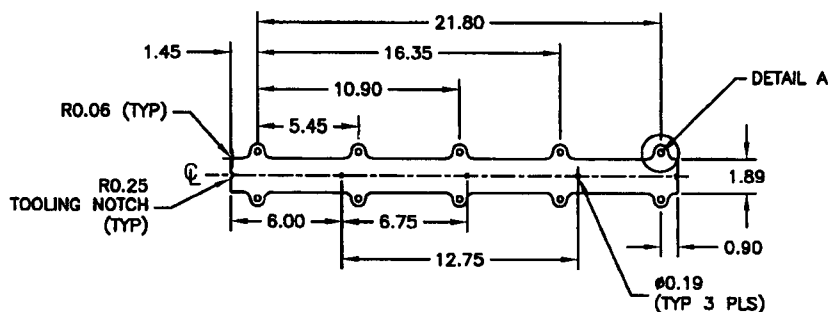
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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 3 OF 6
				SCALE
				1:10

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07.02.12



D3536-23 GASKET

w/o 42007



D3536-25 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT CL
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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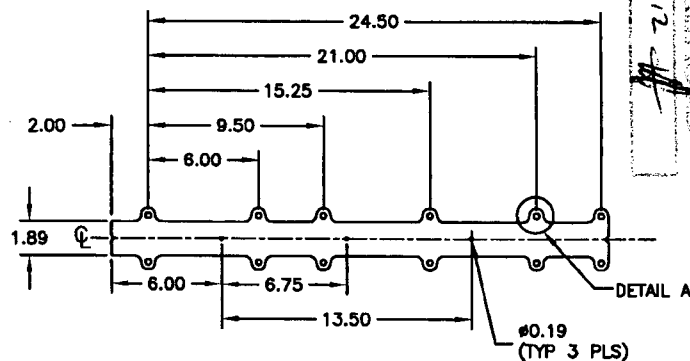
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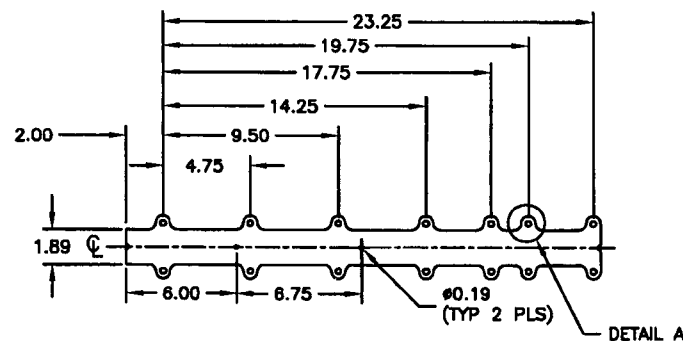
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DATE	06.10.25	TITLE	D3536	REV. A
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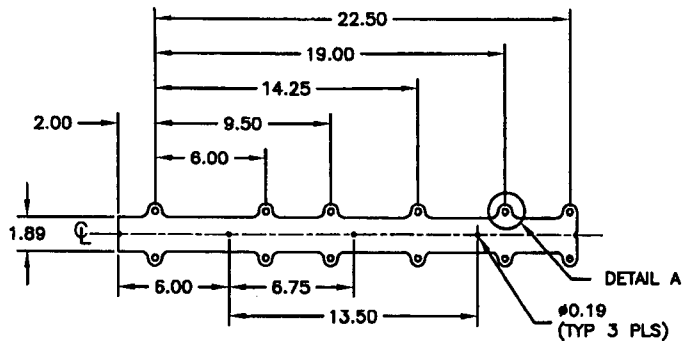


D3536-33 GASKET

W/O 62007



D3536-35 GASKET



D3536-31 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
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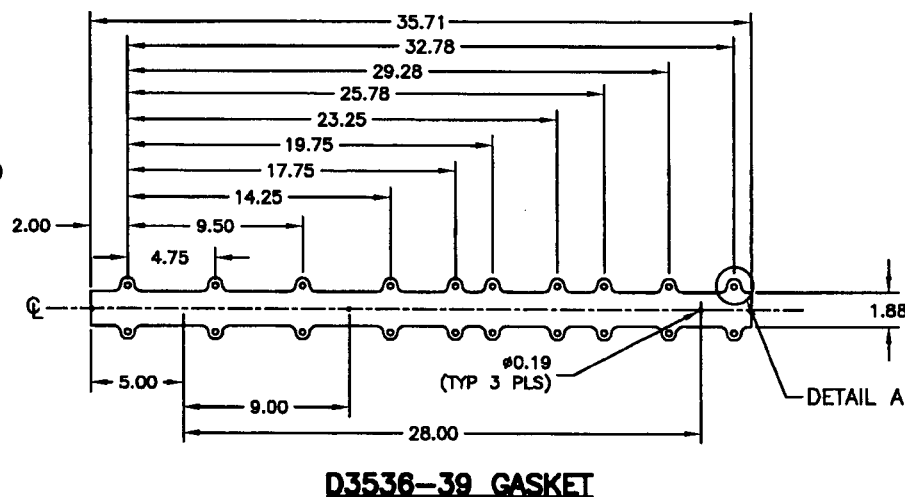
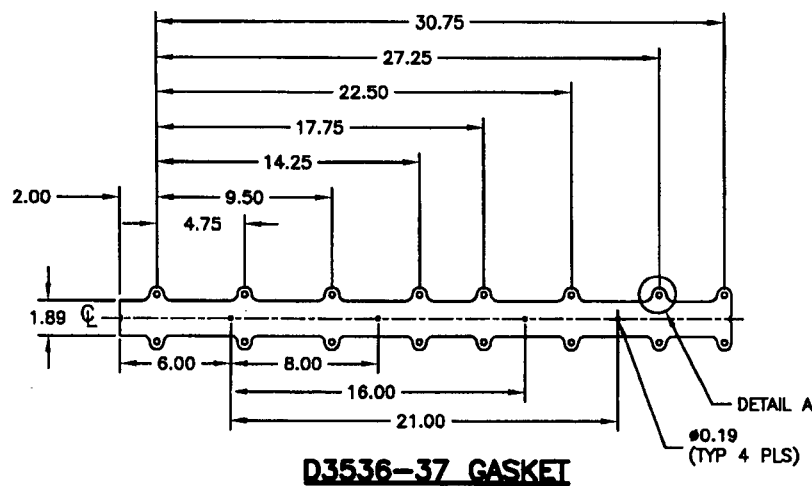
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DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A
		GASKET		SHEET 5 OF 6
				SCALE 1:10

07.02.12
H

w/o 62007



NOTES

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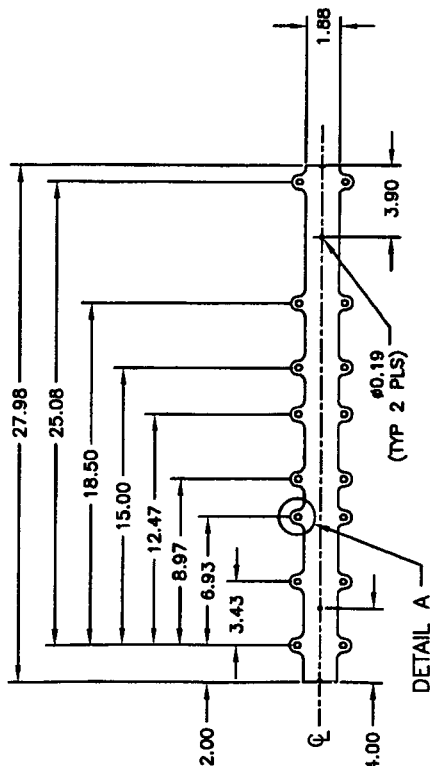
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CHECKED PH	APPROVED [Signature]	DRAWING NO. D3536	REV. A SHEET 6 OF 6
DATE 06.10.25	TITLE GASKET	SCALE 1:10	

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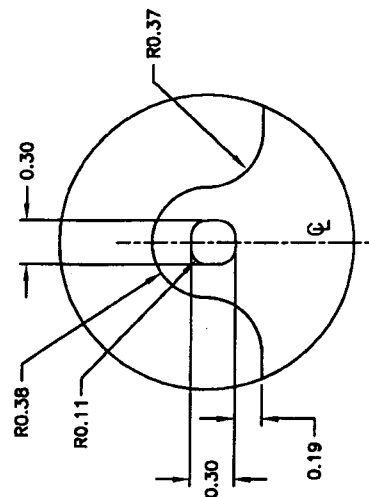
w/ 62007



DETAIL A

D3536-41 GASKET

DETAIL A



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